Work Orde Monday, Septem											Page
	D3578-041	-		Accept					Setup Sta	rt	
Revision ID: Item Name:	Doubler								Sto	р	
Start Date: Required Date: Reference:	9/27/2010 10/4/2010	Start Qty: 60.00 Req'd Qty: 60.00	i (1814) 1 844 1844 1884 1844 1844		Cust Item 1 Customer:	D:				, , , , , , , , , , , , , , , , , , , ,	
Approvals:	Process Pla	an:	Date:/0-9-27	7 Tooling:	D	ate:	_	J	Run Sta	rt	
	QC:	<i>"</i>	Date:	SPC (Y/N):	D	ate:			Sto	P	
Sequence ID/ Work Center II)	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3578	Rev	v A									
100 Waterjet		FLOW WATER JET Memo		0.00				IB	10-9-3	چ	
FLOW CNC Waterje		1-Cut as per Rev:	Dwg D3578 (Run prog. I □2-Deburr if necessary	PK						T)
110 QC		QC2- Inspect parts off ma	achine FAI/FAIB	0.00	/ '			P3	10-9-31	٥	

20

QC Quality Control

Quality Control

120

QC8- Inspect parts - second check

Memo

	•									
W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Y	es N	o DQA	\ :	Date: _	<u> </u>
	Re	solution:	Disposition	ı:	_ QA: N/0	Clos	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)				
DATE	OTED	Description of NC		Corrective Action Section 6		Veritic		cation Approval	Annroval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section		Chief Eng	QC Inspector
					·	•				

Work Order ID 62335

Monday, September 27, 2010 11:30:52 AM



Page 2

Item ID:

D3578-041

Accept

Setup Start

Stop

Revision ID: Item Name:

Start Date:

Doubler

9/27/2010

Start Oty: 60.00 Reg'd Oty: 60.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: Date: Tooling:

Date:

Run Start



Required Date: 10/4/2010

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/ Run Hours

0.00

0.00

Memo

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

Tool ID

Tool # Plan Code

Accept Otv

Reject Reject Qty

Insp. Number Stamp

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

0.00 pl 10-10-12

Cohros

150

HandFinish

0.00

Hand Finishing

Memo

Memo

Chemical Conversion Coat per OSI005 4.1

W/O:			WORK ORDER (CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								·
Part No	:	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date: _	
	Resolution]:	Disposition:	QA: N/C (closed:		Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B								
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector				
					-							
					ļ.							

Work Order ID 62335

Monday, September 27, 2010 11:30:52 AM



Page 3

Item ID:

D3578-041

Accept

Setup Start



Revision ID:

Start Date:

Item Name:

Doubler

9/27/2010

Start Qty: 60.00

Req'd Qty: 60.00



Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 10/4/2010

Process Plan:

Date: Tooling:

Date:

Run

Start

Stop



QC: ____ Date:____

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Stop

Reject

Qty

Insp.

Stamp

Sequence ID/ **Work Center ID**

160

QC

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

0.00

0.00

Tool ID

10/16/12

75 9

Accept

Qty

Number

Reject

170

Small Fab

Small Fab

Small Fab

Memo

1-Assemble as per dwg D3578

0.00

0.00

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00 Memo

Stolal19



rospace Lt	d							
		W	ORK ORDER CHANG	GES				
STEP	PR	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Reso	olution:	Disposition	on:	QA: N/C C	losed:		Date: _	
		WORK ORD	ER NON-CONFORM	ANCE (NC	R)			
STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	Sign	& Sect		Approval Chief Eng	Approval QC Inspector
	·							
	STEP	Resolution: Description of NC	STEP PROCEDURE CHA PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A STEP Section A STEP Description of NC Section A Initial Action Description	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NCI STEP Description of NC Section A Section B Sign	STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DQ Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty :PAR #:Fault Category:NCR: Yes No DQA: Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr E:PAR #:Fault Category:NCR: Yes No DQA:Date: Resolution:Disposition:QA: N/C Closed:Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Section C Section C Section C Section C Section C Section C Chief Eng / Prod Mgr

Work Order ID 62335

Monday, September 27, 2010 11:30:52 AM



Page 4

Item ID:

D3578-041

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Doubler

9/27/2010 **Start Qty: 60.00**

Req'd Qty: 60.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Required Date: 10/4/2010

Date:_____

SPC (Y/N):

Date: ___

Stop



Sequence ID/

Work Center ID

190

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Set Up/

Run Hours

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Reject

Insp.

Number Stamp

Packaging

0.00

200

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/20 X) MF 10-10-19

W/O:			V	VORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						w 			
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date:	`
	R	esolution:	_ Disposit	ion:	QA: N/C C	losed:		Date: _	
NCR:		W	ORK OR	DER NON-CONFORMAN	ICE (NC	R) .			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
									i
		<u> </u>						1	

Picklist Print

Monday, September 27, 2010 11:30:57 AM

Work Order ID: 62335

Parent Item:

D3578-041

Parent Item Name: Doubler



Start Date: 9/27/2010

Required Date: 10/4/2010

Page 1

Start Qty: 60.00

Required Qty: 60.00

IPP: A□07.04.11□New issue□EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3569-1		Manufactured	No			110	Each	22.0000	1	60			
Decal	IIII IIII A						N	A				7	10
•	U			Location		Loc	Oty	Loc Code					
				ST245A			22						
					32084		22		_				
1S20426AD3-3		Purchased	No			110	Each	4,589.000	2	120 150	2		
111111 1111										01	1/		
Rivet										10,0	110/19		
				Location		Loc	<u>Oty</u>	Loc Code		•	·		
				ST316			4589						
					19099		4577		_	150			
460617760.000					7681		12		_				
// // // // // // // // // // // // //	BIII BIB SB (1811) PRI CO 1814 BAN ING	Purchased	No			170	sf	106.0512	0.007	0.442105			
										lb	10-9-	2.∖	
061-T6 .080 Sheet													
				Location		Loc	<u>Oty</u>	Loc Code			(/.	15)	
				MAT			106		_				
					115689		106		_				
				MAT21	112420		0512		-	10/00			
MS21075L3		D1	Ma		113438		0512	•••••		13438			
	PHYLEN EEE HILL LEEL	Purchased	No			170	Each	50.0000] 	60		/	
										Bo	10/0	8	
Jutplate												_	
				Location		Loc	_	Loc Code		•	M115	908	B
				ST303	110504		50		/_		1	2	•
					113734 114760		1 49		<u>-</u>	13	(
		•			114/00		49		_	<u> </u>			

W/0:62	335	WORK ORDER CHANGES			• • • • • • • • • • • • • • • • • • • •		
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0109		PANTINENT MANDE remove A 3569-1	DV	04.01.0		12/09	

Part No: D3578-04 PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANC						
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A			Sign & Date	Section C	Chief Eng	QC Inspector
						·		

DART AEROSPACE LTD	Work Order:	42335
Description: Doubler	Part Number:	D3578-1
Inspection Dwg: D3578 Rev: A		Page 1 of 1

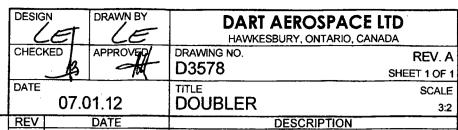
. .

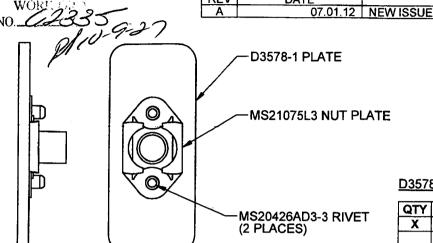
	FIR	ST ARTICLE	E INSPEC	TION CH	ECKLIST		
		X First A	rticle	Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	mments
Ø0.098	+0.004/-0.001	1099	¥		V Bas		
Ø0.203	+0.005/-0.001	, 204	*		V		
0.63	+/-0.030	,630	4		ν		
1.50	+/-0.030	1.501	10		V	,	
0.500	+/-0.010	,506	9		V		
0.250	+/-0.010	. 250	2		V		
0.50	+/-0.030		*		V		
0.313	+/-0.010	1313	*		V		
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							···
 							
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·							
Measured by:	IB	Audited by	: 2		Prototype App	roval:	N/A
Date:	10-9-30	Date		04		Date:	N/A
Rev Date	Change				Revis	ed by	Approved
A 07.11.23	07.11.23 New Issue P/O D3578-041				K.I/E(C/DD -Z/	

H:\FORMS\Quality Assurance\approved QA\FAI revD

W/O:			WO	RK ORDER CHANGI	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·					
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	·
Resolution:		esolution:	Disposition	QA: N/C C	osed:	Date:			
NCR:		1	WORK ORDE	R NON-CONFORMA	NCE (NCF	?)			
		Description of NC	Corrective Action Section		on B	Vorifie	Verification	A	Annexal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Secti	tion C	Approval Chief Eng	Approval QC Inspector
							•		







RELEASED

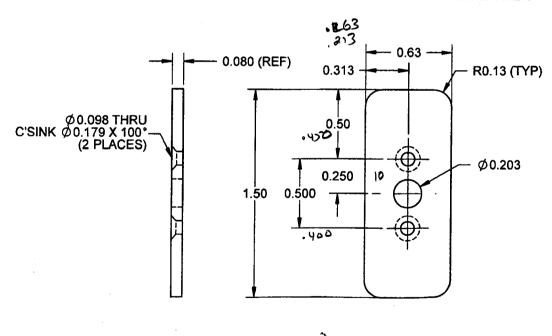
D3578-041 PARTS LIST:

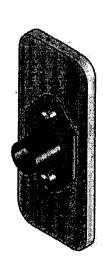
QTY	P/N	DESCRIPTION
Х	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER

D3578-041 NOTES:

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER





D3578-1 PLATE

D3578-1 NOTES

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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Dart Ae	rospace	Ltd							
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								i	
			·						
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A :	_ Date: _	
Resolution:			Disposition	QA: N/C CI	QA: N/C Closed:			Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
	STEP	Description of NC	Corrective Action Section B		n B	Verifi	ication	Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8		tion C	Chief Eng	QC Inspector
					ŀ				